

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012736**Date Inspected:** 11-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port

Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

In- Process Inspections:

Welding of 7AW to 7BW edge plate splice weld.

ABF MT of weld repairs on section 6CW at the cross beam splice area.

ABF MT of section 6CE base metal repairs on the deck plate at the 6CE/ 7AW splice.

ABF MT of section 6CW at PP47 Longitudinal Diaphragm, cross beam side, at the 6CW/ 7AW splice.

ABF MT of section 6CW weld repairs at the cross beam splice area.

Blasting operations on sections 6AE, 6BE, 6CE, bike path and crossbeam sides.

Welding by ZPMC personnel of "T" stiffener terminations at the 6CW/ 7AW splice, on the cross beam side.

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Grinding of the weld profile on “T” stiffeners on section 6CW, cross beam side, at the 6CW/ 7AW splice.

ABF MT on section 6AW at PP38 at the cross beam splice hold back area.

ZPMC personnel grinding weld profile at PP39 at the cross beam splice hold back area.

SMAW welding of section 7BW/ 7CW side plate, cross beam side. The weld procedure in use was identified as WPS- B-P-2214-B-U2-FCM-1. The welding personnel were identified as 045196, 066361, 066258, and 066326.

SMAW welding of section 7BW/ 7CW bottom plate. The weld procedure in use was identified as WPS- B-P-2214-B-U2-FCM-1. The welding personnel were identified as 067752, 037996, and 067589.

Non- Destructive Testing

This inspector performed conventional ultrasonic testing, UT, on section 7BW, deck plate to edge plate, counterweight side in accordance with scanning pattern “D”. This inspection was in conjunction with ABF, and in accordance with the approved “D” scan procedure. Additional indications were found during the inspection, and were noted on the ABF UT report. For more information on indications, see the ABF Ultrasonic Testing report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
